

Work Order ID 86294

86294

Page 1

June-26-12 3:38:18 PM

Item ID: D3723-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bushing

Stop *NS2*

Start Date: 26/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/26

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3723	Rev A								
100		0.00							
100	CONVENTIONAL LATHE								
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn as per dwg D3723								
	FOLIO REV: 4A								
	DWG REV: 4								
	DEBURR								
105		0.00							
105	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

DAS
14
2-89

12/07/29

25

DAS
14
2-89

12/07/29

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC8- Inspect parts - second check	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>067</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12-7-29

25 7

12/17/20 25

12/17/31 7

MLJ 12/07/30

W/O:		WORK ORDER CHANGES					
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Picklist Print

June-26-12 3:38:21 PM

Page 1

Work Order ID: 86294

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Parent Item: D3723-1

D3723-1

Parent Item Name: Bushing

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev. A 08.02.15 New issue EC
IPP Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750		Purchased	No			100	f	147.3720	0.02	0.252632			

MDFI RINR0 750

**

Delrin Round Bar 0.75"

Location

Loc Qty

Loc Code

MAT055

147.372

116183

2.4

117273

1.555

117322

0.94

120722

5.28

→ 121783

137.197

625

OK 12/07/29

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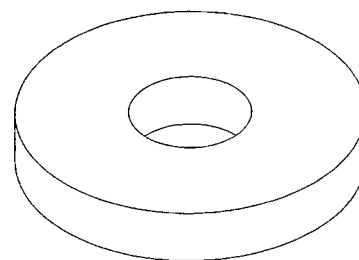
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 86294 MLJ

12/06/26



D3723-1 BUSHING

RELEASED
 12/06/26

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, ROD
 (REF DART SPEC M-DELRIN-R)
 OR DELRIN II 150E OR ACETRON GP ACETAL, BAR
 (REF DART SPEC M-DELRIN-B)
 OR DELRIN II 150E OR ACETRON GP ACETAL, SHEET
 (REF DART SPEC M-DELRIN-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs APPROX

A	NEW ISSUE	AJS	08.02.11
REV.	DESCRIPTION	BY	DATE
DESIGN		AJS	
DRAWN		MLJ	
CHECKED		MLJ	
MFG. APPR.		MLJ	
APPROVED		MLJ	
DE APPR.		MLJ	
DATE	08.02.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3723	REV. A SHEET 1 OF 2
TITLE BUSHING	SCALE NTS

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W/O:		WORK ORDER CHANGES					
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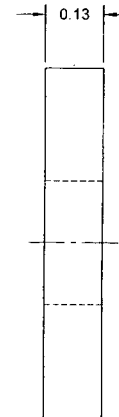
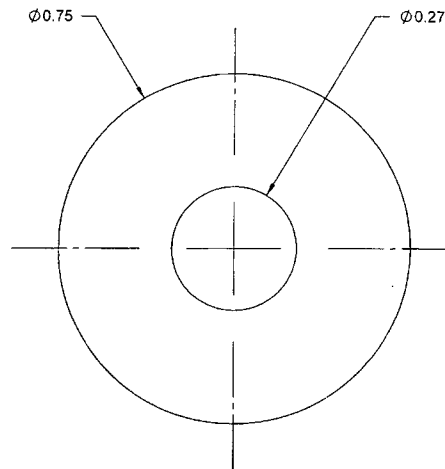
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86294



D3723-1 BUSHING

RELEASED
16 08-02-25

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3723	SHEET 2 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BUSHING	4:1
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